
















Date: Monday, 27/10/2008 2:16:22 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-BOLT SPACER
Job Number	: 42979	Part Number	: D34903
Estimate Number	: 12323	Drawing Number	: D3490 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 27/10/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: // Type : MACHINED PARTS	Due Date	: 10/11/2008 Qty: 60 Um: Each
Previous Run	: 42186		
Written By	:		
Checked & Approved By	: <u>JUL 08.10.28</u>		
Comment	: Est Rev:A New Issue 06-03-03 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0750	6061-T6 Round Bar .750"	
			
Comment: Qty.: 0.2793 f(s)/Unit Total: 16.7580 f(s) 6061-T6 .750" ROUND BAR (M6061T6R0750) Batch: <u>M109807</u> <u>08/11/07</u>  <u>60 pcs</u>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA629 & DWG D3490 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED <u>08/11/07</u>  <u>60 pcs</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>08/11/07</u>  <u>60 pcs</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>08/11/07</u>  <u>60</u>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>BARCLAY</u> <u>08/11/10</u> <u>Bo</u>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3490-3 PAR #: N/A Fault Category: Prod. Mactb. NCR: Yes No DQA: JA Date: 08.11.11
 (0350-636-011/012) Resolution: Accepted Disposition: Use as is QA: N/C Closed: JA Date: 08/11/20

NCR: <u>42979</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.11.07	2.0	Qty of parts are too short by 0.001" → 0.0015" Starting origin was off by 0.0015" R.C. operator error	 08.11.11 08/11/12 08/11/12	parts acceptable. Have employee inspect in accordance with QSP019 or every 15-30 parts.	 08/11/07	 08.11.07	 08.11.11 08/11/12	 08.11.07

NOTE: Date & initial all entries

Date: Monday, 27/10/2008 2:16:22 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 42979

Part Number: D34903

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CMF 08-11-10

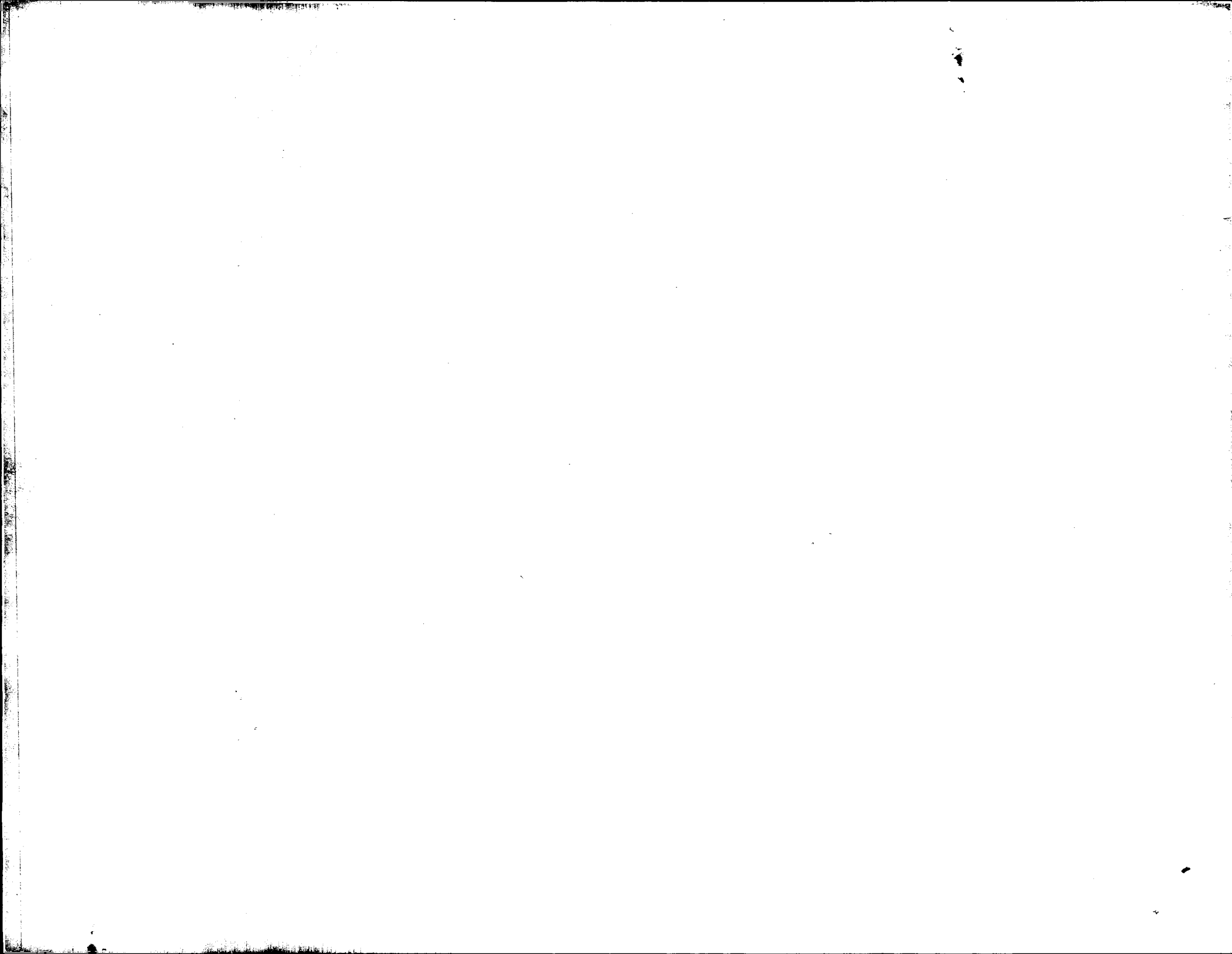
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

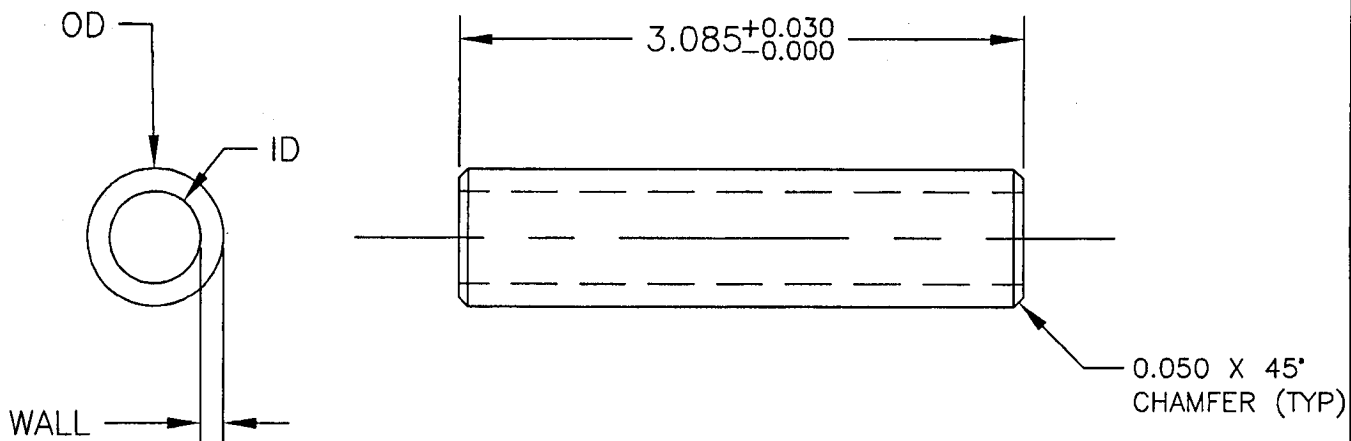
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 42979

RELEASED
06.02.07

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.